

5/23

DART AEROSPACE LTD	Work Order:	23369
Description: Window Assembly # 04.06.09	Part Number:	D3136-041
Dwg: D3136 Rev. B C	Qty:	20
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.05.25	20
2	PG	Issue P/O: <u>L008120</u> Order D3136-1 per Dwg D3136 Supplier: -Canus Material: Polycast II Clear Acrylic sheet per MIL-P-5425 0.125" thick Apply 3M Protective Masking Film both sides Material release note required	U	05/05/26	20
3	RG	Receive and Inspect for transit damage Ensure that material release note is attached	CZ	05/07/04	20
4	QC6	Inspect dimensions as per Dwg D3136	Z	05-08-03	20
5	GA	Trim back masking film as per Dwg D3136 and apply D3108-9 decals to inside surface of windows. B22608 B20476 D3108-9 Batch: <u>B20476</u>	ml	05/08/03	20
6	GA	Engrave Part number and Batch number as per Dwg D3136	ml	05/08/05	20
7	QC5	Inspect work to Step 6	Z	05-06-11	20
8	ST	Identify and Stock as D3136-041	CZ	05/08/11	20
9	AC	Cost / part <u>59.70</u>	SUC	05-08-15	20
10	DC	Close W/O <u>59.44</u> Inspect Level 21	U	05/08/12	20


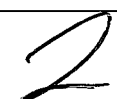
PTO



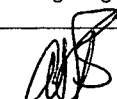

PTO


Rev	Date	Change	Revised By	Approved
A	03.11.28	New issue	KJ/DS	
B	04.02.04	Reformat	KJ/DS	

5	ST	Identify & stock as D3136-1	ml	05/08/03	20
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RELEASED
04-02-04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-08-11	6	A location dimension to where Abuots to scribe on the window for the part's Batch number on the Dwg to ensure #'s are not too high up on the window Permanent Change				 05/08/11	 05-08-11	





NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/08/03	5	There's 5 labels - expired D31089 B20407 exp. date 04/02/25		Scrap them because the date and they weren't the same color.	 05/08/03	 05-08-10	 05/08/15	 05-08-10

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/09/15

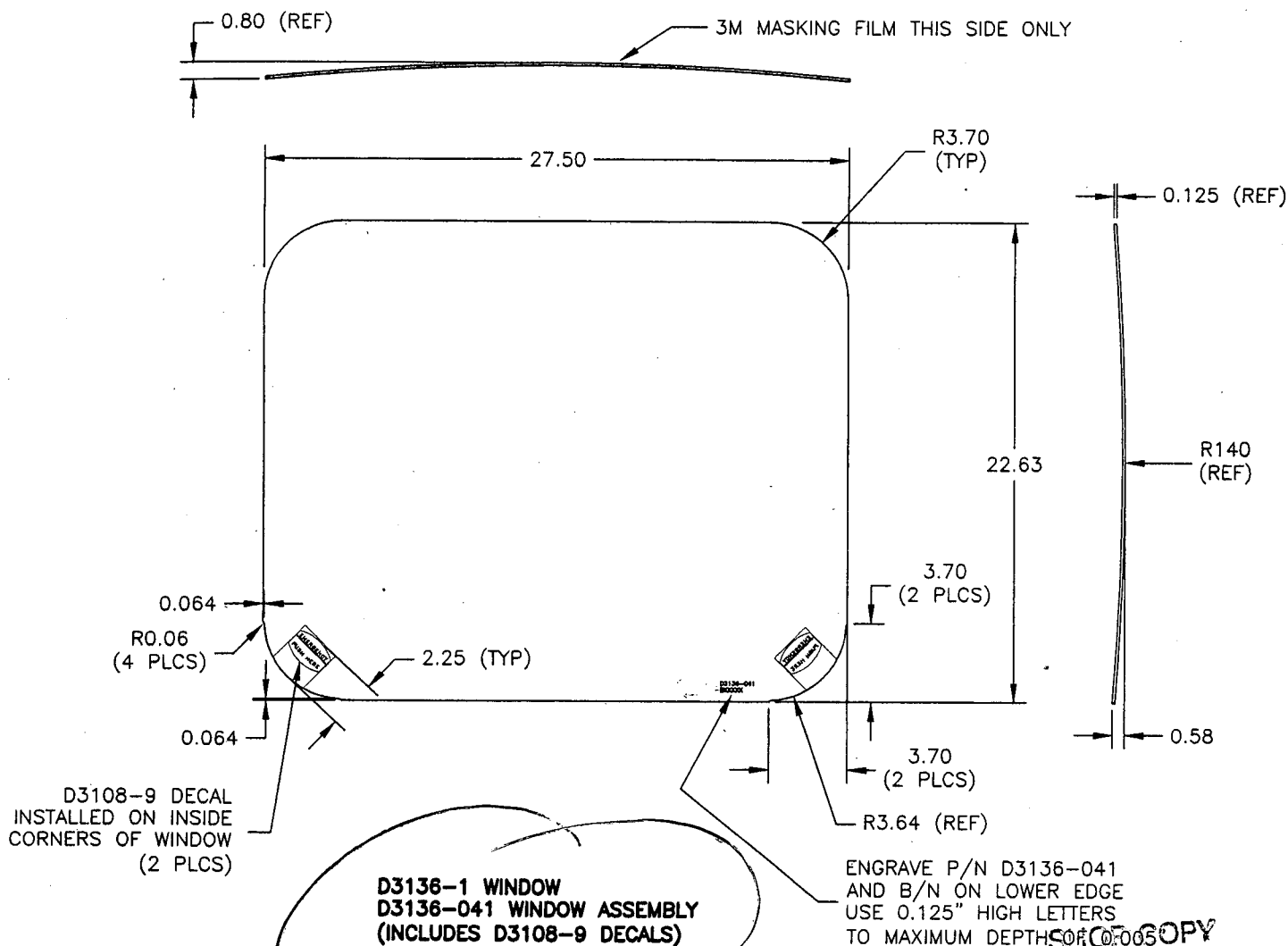
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D3136	REV. C SHEET 1 OF 2
DATE 04.05.05		TITLE WINDOW ASSEMBLY SCALE 1:8			
A	02.04.18		NEW ISSUE		
B	04.01.21		ADDED D3136-3 AND D3136-043		
C	04.05.05		ADDED FORMING & ENGRAVING SPEC		

RELEASED
04.05.12 *[Signature]*



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 0.125 THICK
- 2) FORMING PROCESS:
 - a) HEAT LARGER PIECE TO 250° F
 - b) DRAPE OVER D3136-T1 MOLD & CLAMP
 - c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS
 - d) TRIM PER TEMPLATE D3136-1T2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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RETURN TO
ENGINEERING

WORK ORDER
NO. 23369

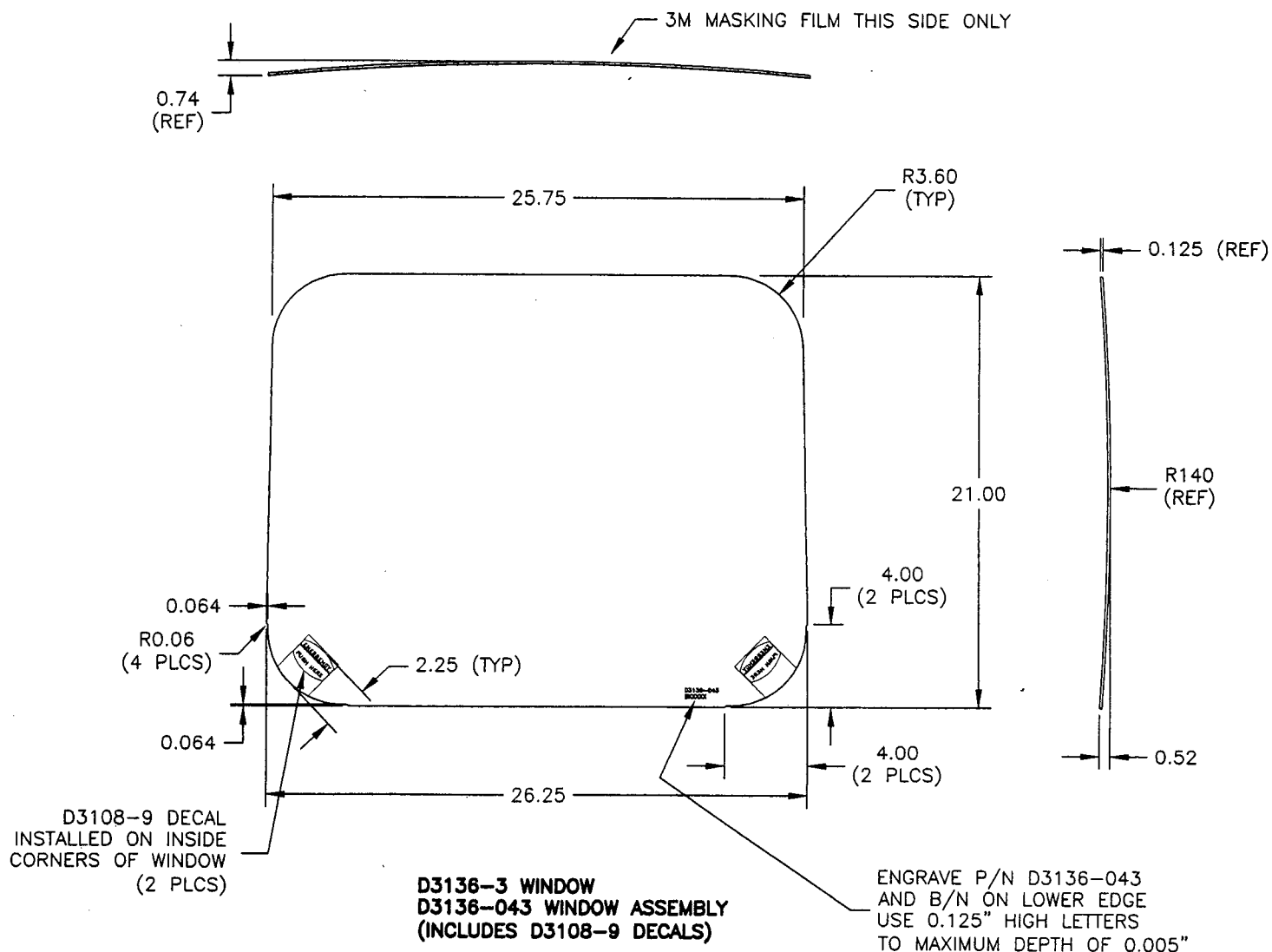
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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3136	REV. C SHEET 2 OF 2
DATE 04.05.05		TITLE WINDOW ASSEMBLY	SCALE 1:8

RELEASED
04.05.12



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS
d) TRIM PER TEMPLATE D3136-3T1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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INSTRUMENT
PRICE

ORDER

23369

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

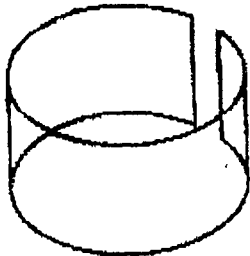
May 18, 2005
03:08 pm

Work Order No : 0023369
Project Name : D3136-1
Project For : WK523
Work Order Type : Main
Main WO Number :
House Part Number : D3136-1
Description : Window
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 05-18-05
Est Finish Date : 06-07-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



CANUS Plastics Inc.
300 Lisgar Street,
Ottawa, Ontario, Canada
K2P 0E2

Telephone (613) 232-2657

CERTIFICATE OF CONFORMANCE

Attention: Receiving Inspection

TO Dart Aerospace Ltd.
1170 Abernethy St.
Hawthorn, Ont.

Date: 6/29/05
P.O. # 2008120
Packing slip # 117678

The undersigned hereby certifies that the materials supplied and the items shipped herewith under the above purchase order and on the packing slip are in conformance with all contractual applicable government specifications and/or purchase order requirements and that physical and/or chemical reports of the materials supplied are on file and will be made available to the buyer and Government upon request.

QUANTITY	DESCRIPTION	SPECIFICATION #.
<u>20</u>	<u>D3136-1 Window</u>	<u>3/4" clear cast Acrylic G</u>
<u> </u>	<u> </u>	<u> </u>
<u> </u>	<u> </u>	<u> </u>

CANUS PLASTICS INC.

[Signature]